

B25353

Dart Aerospace Ltd.

Date: Monday, 6/19/2006 1:26:38 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SADDLE
 Job Number : 27654
 Estimate Number : 12451
 P.O. Number : N/A Part Number : D35001
 This Issue : 6/19/2006 S.O. No. : N/A Drawing Number : D3500 PREL
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : PREL
 Previous Run : N/A Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 6/26/2006 Qty: 4 Um: Each
 Checked & Approved By : [Signature]
 Comment : Est Rev:A New Issue 06-06-15 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. SD Double check by: JG

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

SD / JL 06/06/21

2.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD / JL 06/06/21

3.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 06/06/21

4

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DL 06/06/22 (4)

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/22 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/19/2006 1:26:38 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 27654

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06-06-22

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PROTOTYPE
FOR SADDLE
TEST N/A 06.06.23

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: B27654
Description: 350 saddle	Part Number: D 3500-1
Inspection Dwg: D3500 , Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST




First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.250	+ .010	.250	✓			
.150	"	.145	✓			
1.820	"	1.815	✓			
.250	"	.255	✓			
.625	"	.630	✓			
1.135	"	1.135	✓			
.110	"	.113	✓			
3.614	"	3.614	✓			
Ø.316		.319	✓			
Ø.257		.258	✓			
6.510	+ .010	6.510	✓			
6.000	"	6.005	✓			
.550	"	.552	✓			
.798	"	.797	✓			
1.125	"	1.125	✓			
2.250	"	2.250	✓			
2.500	"	2.500	✓			
2.825	"	2.829	✓			
1.585	"	1.585	✓			
.500	"	.501	✓			
.250	"	.249	✓			
Ø.484		.486	✓			
.500	+ .010	.495				

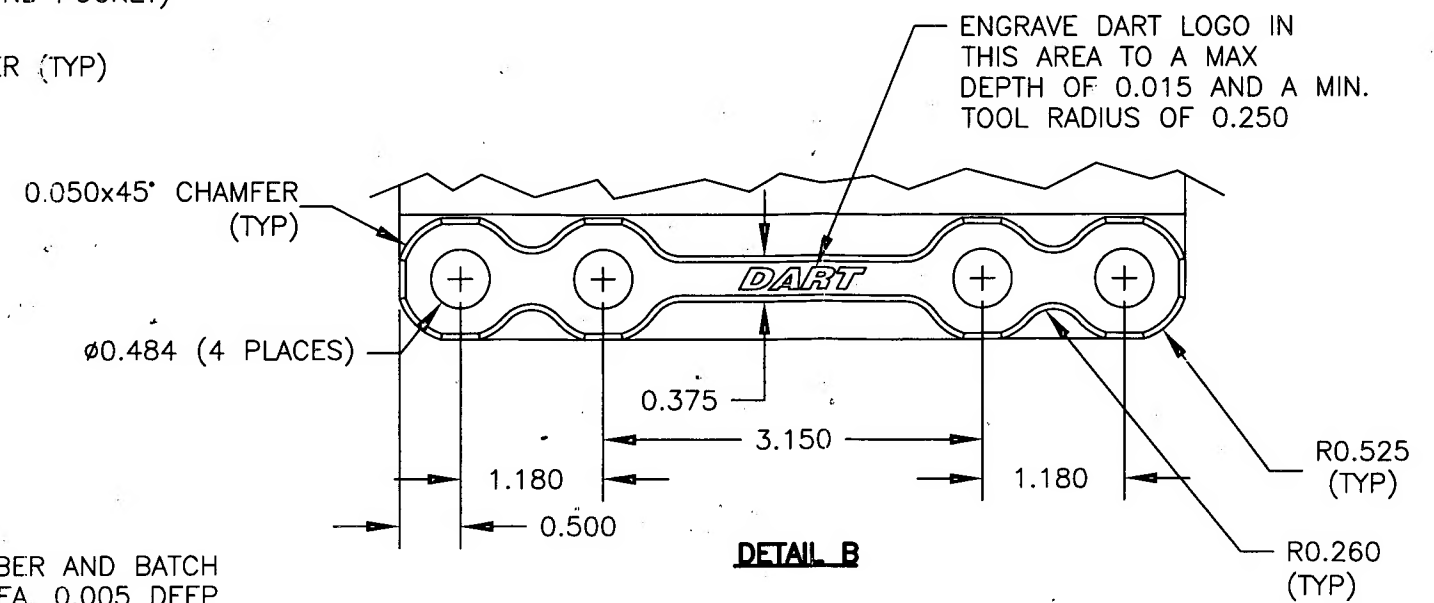
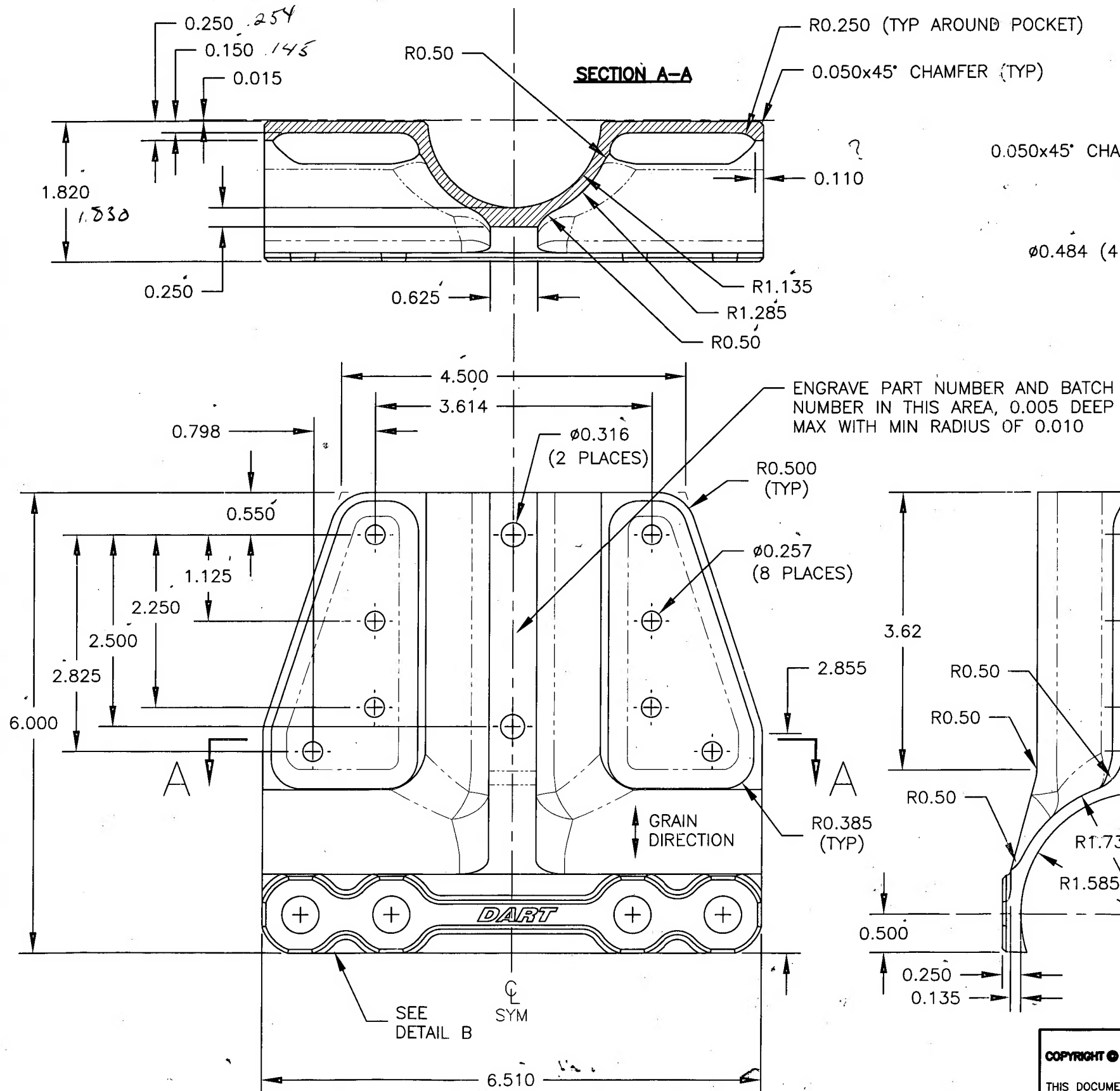
Measured by: J.L.	Audited by: ml	Prototype Approval: 
Date: 06/06/20	Date: 06/06/21	Date: 06.06.20

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

1.374

1.370

1



D3500-1 SADDLE

- 1) MATERIAL: 7075-T7351 ALUMINUM (QQ-A-250/12, REF DART SPEC M7075T73B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

PRELIMINARY ISSUE

06.06.19

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B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3500 REV. B SHEET 1 OF 1
DATE	06.05.29	TITLE SADDLE SCALE 2:3

06.05.09

Metay Cestle